

Date: Monday, 4/10/2006 11:14:27 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DUMP OUTLET |
| Job Number | : 26616 | | |
| Estimate Number | : 12166 | | |
| P.O. Number | : N/A | Part Number | : D3475041 |
| This Issue | : 4/10/2006 S.O. No. : N/A | Drawing Number | : D3475 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : SMALL /MED FAB | Drawing Revision | : A |
| Previous Run | : 26175 | Material | : N/A |
| Written By | : <u>See Comment Below</u> | Due Date | : 4/28/2006 Qty: 1 Um: Each |
| Checked & Approved By | : <u>06.04.10</u> | | |
| Comment | : Est Rev: A New Issue 06-02-03 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|------|
| 1.0 | D34753 | TUBE |
|-----|--------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|----------|
| Qty | Part Number | Description | Batch |
| 1 | D3475-1 | Tube | B26124-2 |

SB 06/04/12

⑧

| | | |
|-----|--------|----------------------|
| 2.0 | D34751 | OUTLET ADAPTER PLATE |
|-----|--------|----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|----------|
| Qty | Part Number | Description | Batch |
| 1 | D34753 | Flange | B26129-2 |

SB 06/04/12

⑧

| | | |
|-----|------------|----------|
| 3.0 | NAS1031C3W | Nutplate |
|-----|------------|----------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch |
| 8 | NAS1031C3W | Nut Plate | M100869 |

SB 06/04/12

⑧

| | | |
|-----|-------------|-------------------------------|
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3479

2-Spot Weld as per Dwg D3475 and Dart QSI 018

SB 06/04/12

⑧

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 22 Date: 04/04/28
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 26616

Part Number: D3475041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5/

WELD INSPECTION



Comment: WELD INSPECTION

060425 (S)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg Dwg D3475

Ensure Certificate of Conformity is attached

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

060425 (S)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

0610428 (S)

Job Completion



060428

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

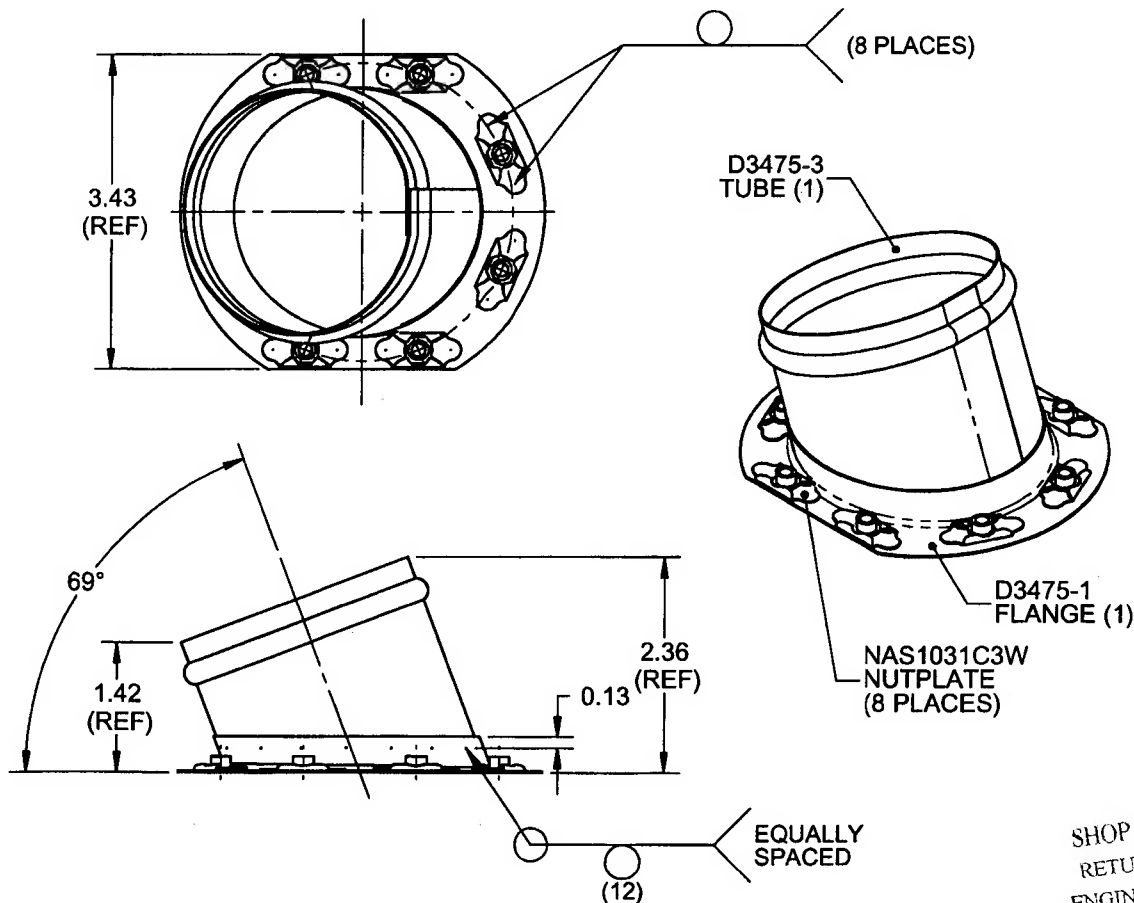
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3475 | REV. A SHEET 1 OF 6 |
| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:2 |
| A | 06.01.24 | NEW ISSUE | |

[Signature] 06.04.03



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NO. *26616*

D3475-041 DUMP OUTLET

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

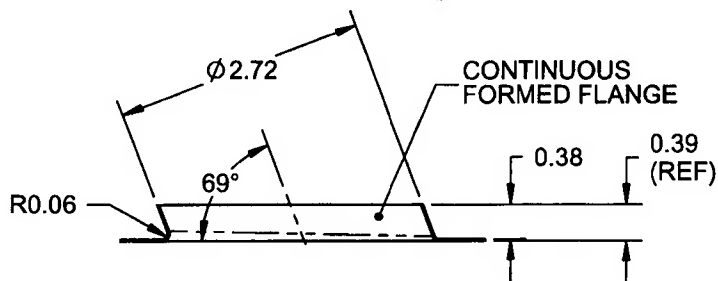
| QTY -041 | P/N | DESCRIPTION |
|-------------|------------|-------------|
| X | D3475-041 | DUMP OUTLET |
| 1 | D3475-1 | FLANGE |
| 1 | D3475-3 | TUBE |
| 8 | NAS1031C3W | NUTPLATE |

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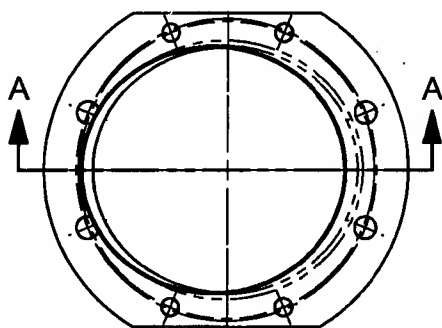
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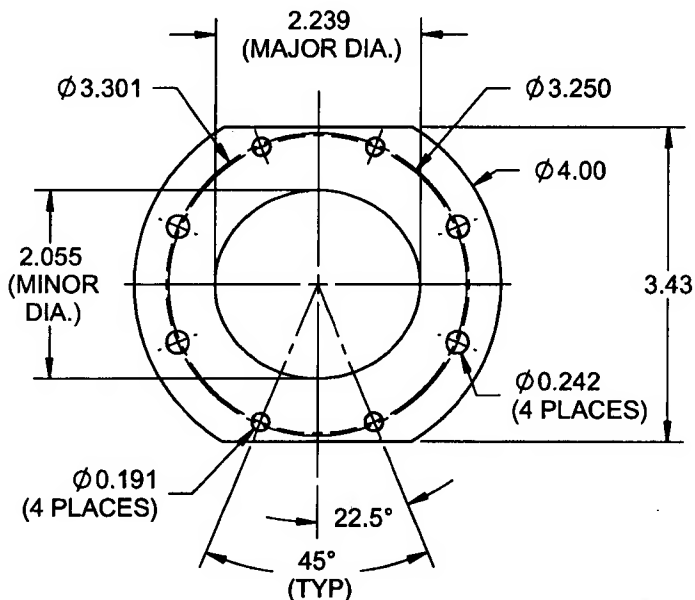
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| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:2 |



SECTION A-A



**D3475-1 OUTLET
ADAPTER PLATE**



D3475-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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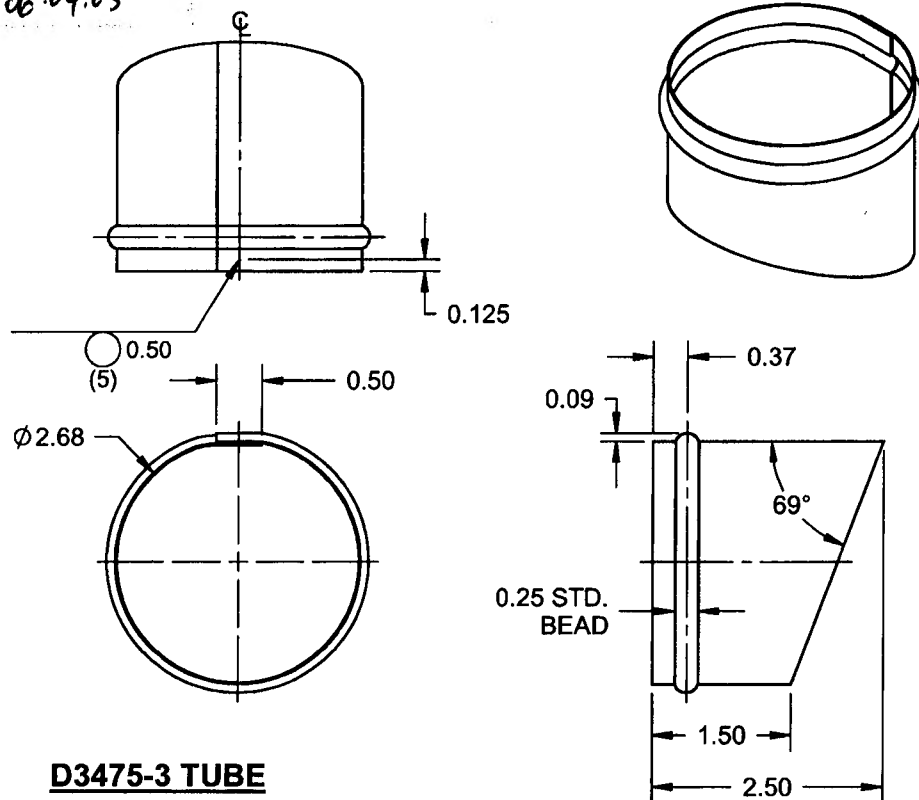
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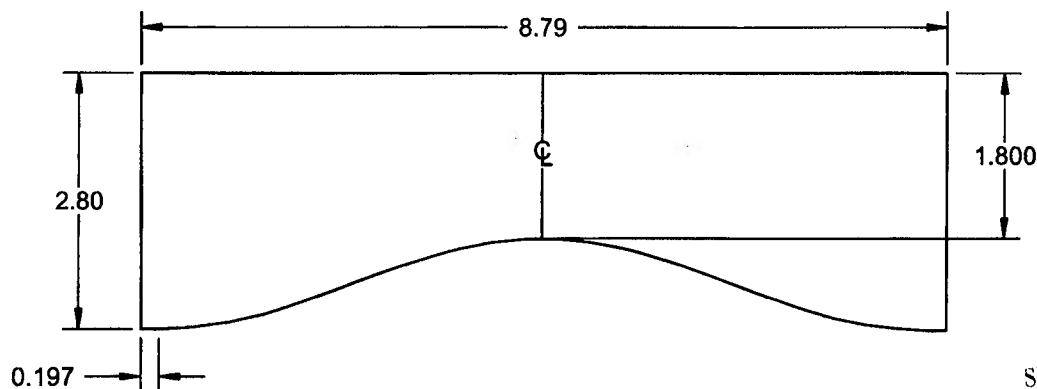


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| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:2 |

06.04.03



D3475-3 TUBE



D3475-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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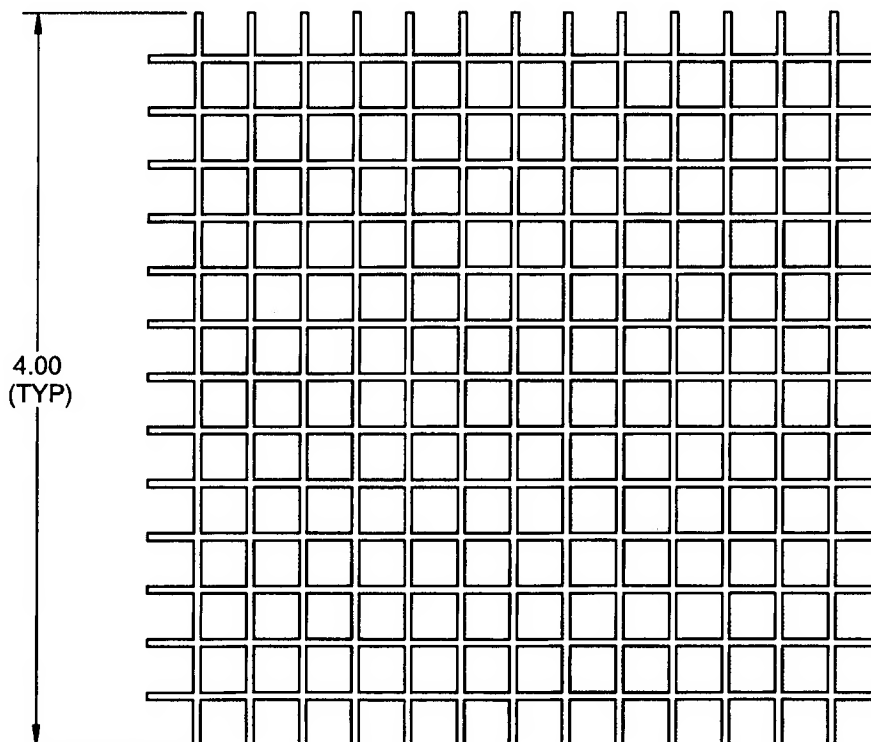
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| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:1 |

06.04.03



D3475-5 SCREEN

NOTES:

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

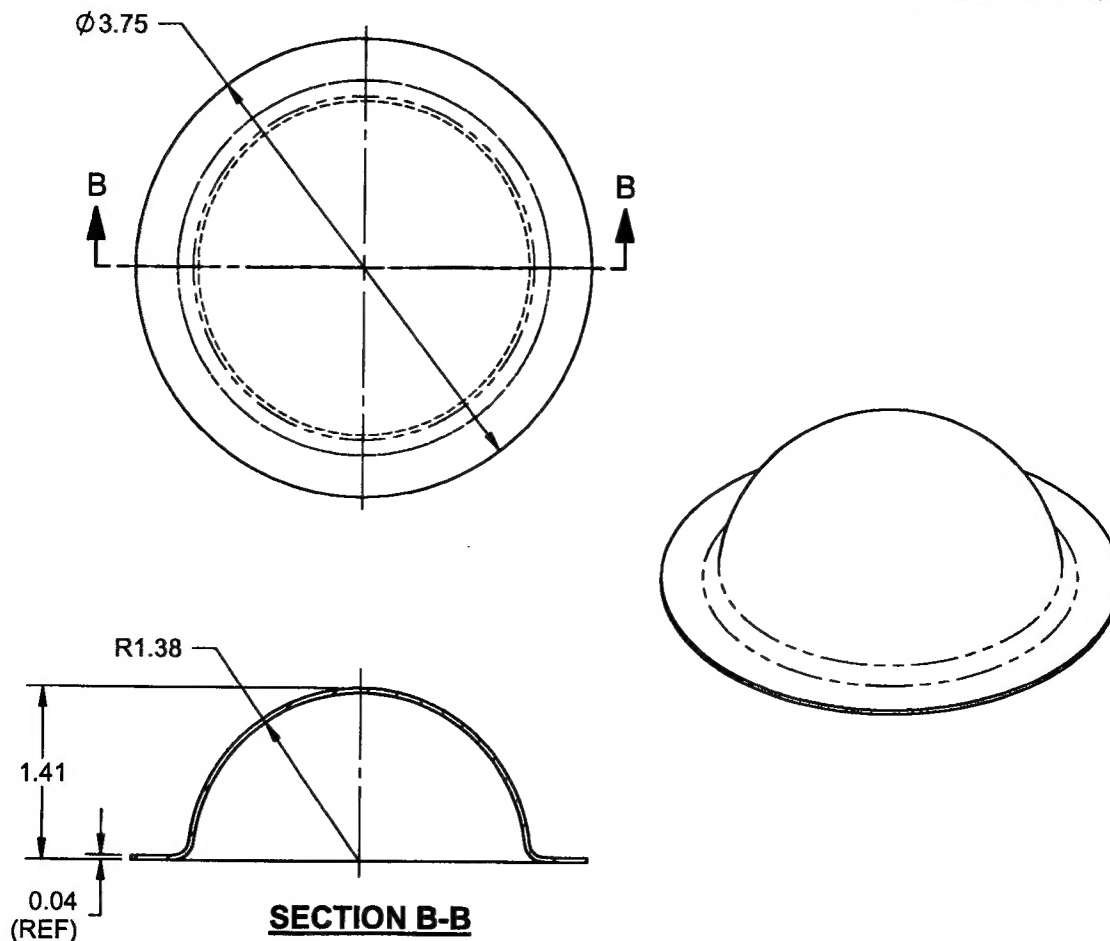
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| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:1.5 |



D3475-7S SCOOP OUTLET, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

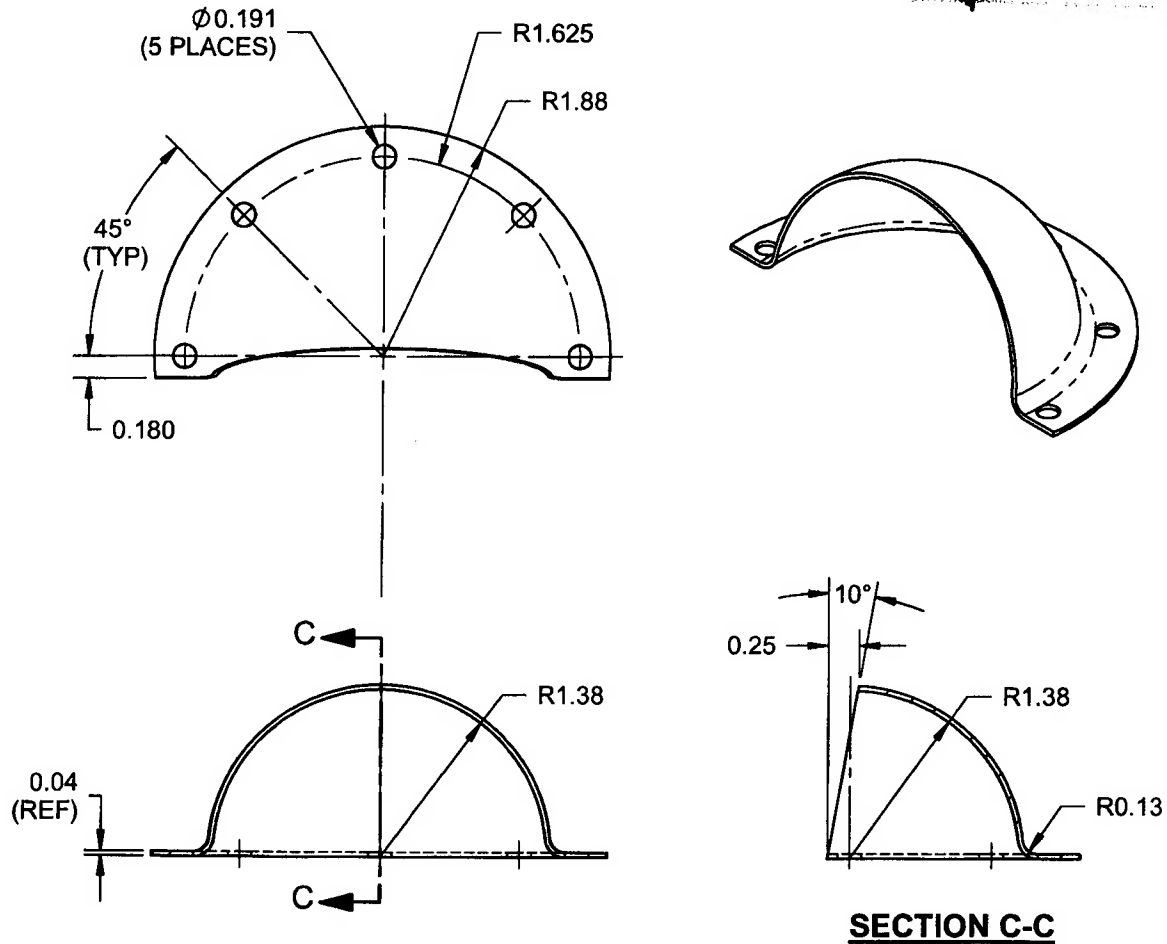
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| CHECKED H | APPROVED H | DRAWING NO. D3475 | REV. A SHEET 6 OF 6 |
| DATE 06.01.24 | | TITLE DUMP OUTLET | SCALE 1:1.5 |

**D3475-7 SCOOP OUTLET****NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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